Work Order ID 95228

95228

Page 1

January-03-13 9:51:49 AM Item ID: D3177-5 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Spacer **Start Date:** 1/04/13 **Start Qty: 10.00 Cust Item ID:** Required Date: 1/04/13 Req'd Qty: 10.00 **Customer:** Reference: Run Start Approvals: Date: **Tooling:** Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID **Description Run Hours** Code Qty Qty Number Draw Nbr **Revision Nbr** D3177 Rev B2 100 0.00 Hardinge CNC LATHE SMALL *100* 10 Hardinge 0.00 Memo I-TURN AS PER FOLIO FA292 & DWG FOLIO REV: Hardinge CNC Lathe Small DWG REV: 2-DEBURR AS REQUIRED QC2- Inspect parts off machine FAI/FAIB 110 0.00 *110* 10 QC 0.00 Memo Quality Control

NCR:	Yes	1	No

DQA: Date:

NCR: Y															
									·			QA Closed:	Date		
Nork Orde	r:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part N	•						Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR No.					Use-as-is Thermofor Work Order Update Large		noforming Large Fab			e/Packaging Supplier	Other				
Root					Desc	rip	otion of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		o	r Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
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		Bending				$\overline{}$	Bend		Grain			Ovalized		Pressure/Forced	
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		Cracks			L		Broken/Damaged		Inspecti	on Incomplete		Part Incorred	it	Weld	
		Crushed/0	Crimped.				Burrs	L	Instruct	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
		Cuffs			Ĺ		Contamination		Mainte	enance		Part Moved			
		Heat Trea	t				Countersink		Mislabe	eled		Positioned V	Vrong _		
		Inspection Strip in Tube Cut Too Short			Cut Too Short		Misread	1		Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes						Offset								
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration				!	
		Turning Se	equence				Finish		Out of S	Sequence					
	Wave/Twist in Tube Folio					Folio		Outside	Dimensions						

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QC

Quality Control

Memo

												DQA:	Date:	
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												QA Closed:	Date	
Vork Orde	\r·						DISPOSITION				AGAINST DI	EPARTMENT/	PROCESS	
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		Cuffs Contamination			Contamination		Mainte	enance		Part Moved				
		Heat Treat Countersink			Countersink		Mislabe	eled		Positioned V	Vrong			
		Inspection Strip in Tube Cut Too Short				Misread	d		Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes					Offset								
		Torque W	aves in E	xtrusio	n [Drawing		Out of	Calibration				
	Turning Sequence Finish					Finish		Out of 9	Sequence					
	Wave/Twist in Tube Folio					Folio		Outside	Dimensions					

Work Order ID 95228 January-03-13 9:51:49 AM D3177-5 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Spacer **Start Qty: 10.00 Start Date:** 1/04/13 Cust Item ID: Required Date: 1/04/13 Req'd Qty: 10.00 **Customer:** Reference: Start Date: Approvals: **Process Plan: Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept **Work Center ID** Description Qty **Run Hours** Code **Qty** 0.00 130 Identify as per dwg & Stock Location: *120*

Packaging

Packaging

Memo

0.00

Reject Number Stamp

Insp.

140

QC21- Final Inspection - Work Order Release

0.00

140

Memo

0.00

MUS 13-01-07 MF 13-04-09

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Skid-tube Crosstube Machining Small Fab Use-as-is Thermoforming Finishing Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other				
											J		
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Cr	nief Eng	Desc	ription	Date	Verification	QC Inspector
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Setup													
Other													
Process													
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Training													
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Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld		
Crushed/Crimped Burrs						Instruct	tions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	enance		Part Moved	_	_
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Vrong	
					Cut Too Short		 				'Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Cut Too Short Drill Holes

Drawing

Finish

Folio

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January-03-13 9:51:49 AM

Work Order ID:

95228

Parent Item:

D3177-5

Parent Item Name:

Spacer

Start Date: 1/04/13

Required Date: 1/04/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A03.01.27New IssueKJ/RF

Comments:	IPP A03.01.27Nev	v issuenj/ni								0.000			
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.000 ROUND BAR 1.00"		Purchased	No				f	74.2190		0.8	inc. Salaga s.a.		
				Location		Loc Qty	<u>Lo</u>	c Code					CAN
				MAT012		24				<u> </u>	15.1	1.4	04
				121	070	24					C,	`	9-89
				MAT013		50.219							
				116	406	12.103							
				118	271	11.4							
				121	192	9.64			A				
				122	521	10			l-143	5,			
				123	483	7.076							

NCR:	Yes	/	No

DQA: _____ Date: ____

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
									· · · · ·		QA Closed:	Date:			
Nork Orde	r:					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
	•			-		Rework	1	Skid-tube Crosstube				Water Jet	Engineering		
Part N	lo.					Scrap	1	Machining Small Fab			Prod	d. Eng. Coor.	Quality		
						Use-as-is]	Thermoforming Finishing			Rec/Stor	e/Packaging	Other		
NCR No.				Work Order Update	┚		Large Fab	Composite		Supplier					
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		Bending				Bend		Grain			Ovalized	_	Pressure/Forced		
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		Crushed/0	Crimped.		L	Burrs	_	4	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs			-	Contamination	\vdash	Mainte		<u> </u>	Part Moved				
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:	_	Ripples in			_	Drill Holes	Offset Out of Calibration								
		Torque W		xtrusio	n -	Drawing	-	•							
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		Wave/Tw	ist in Tub	e		Folio	1	JOutside	Dimensions						

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		11/5/197
D3065-5DART AEROSPACE LTD	Work Order:	7766
Description: Spacer	Part Number:	D3177-5
Inspection Dwg: D3177 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Г	TAKTICLE IN	_				
	L	X First Artic	cle _	Prot	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method of		nments
Dimension	loierance	Dimension	Accept	Keject	Inspection	ı Coi	IIIIeiits
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0.383 - 0.381	N/A	- 382					
0.626	+0.001/-0.000	. 626					
0.455	+/-0.010	. 455					
Ø1.000	+/-0.005	- 997					
0.063 x 45°	+/-0.010	.0.63		,			
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Measured by:	3-89	Audited by:	2300 23300		Prototype	Approval:	N/A
Date:	2.2.	Date:	13.01.0	، در		Date:	N/A
Rev Date	Change				· ·	Revised by	Approved
A 04.02.25						KJ/RF Ø	

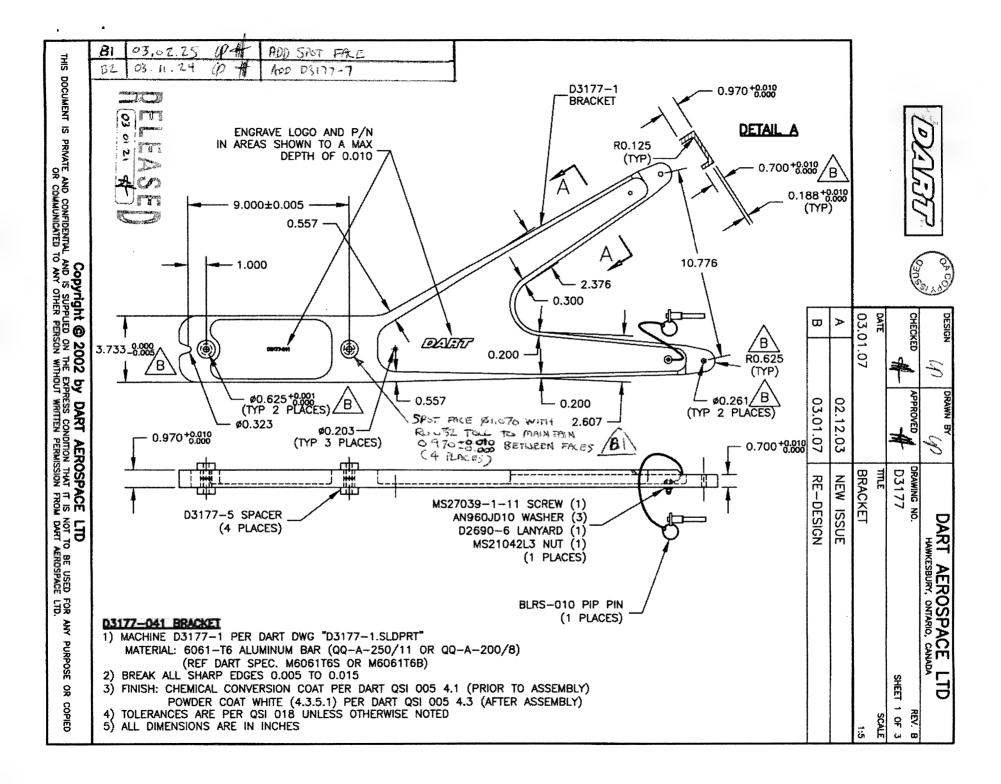
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Vork Orde	r:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Water Je Prod. Eng. Coo Rec/Store/Packagin Supplie		Engineering Quality Other		
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Ì	-	Ripples in		·ube			Drill Holes		Offset	•	. L.	J. 04461 2033/	~~.80	10
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	Torque Waves in Extrusion Drawing Turning Sequence Finish				-		1	Sequence						

Outside Dimensions

Wave/Twist in Tube

Folio

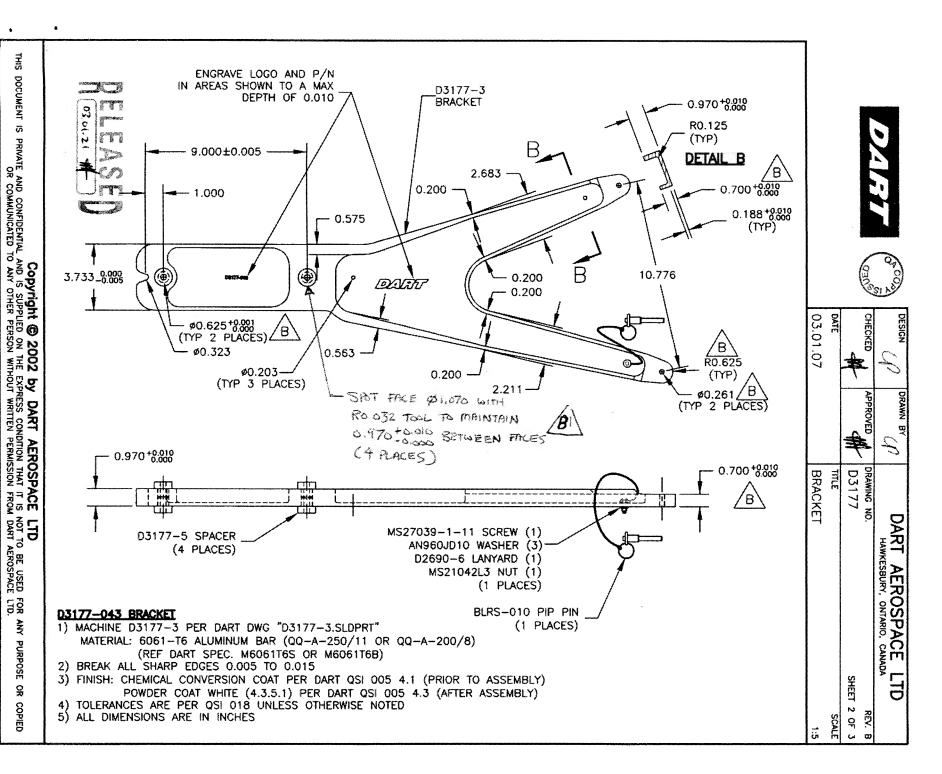
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		DQA:	Date:	7
NCR: Yes /	No WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	j.
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier		
Root					Descri	ption of work order update	11	nitial	Act	tion	Sign &		
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NCR:	Yes / No	WORK ORDER NON-CON

DQA:	Date:	<i>*</i> 2

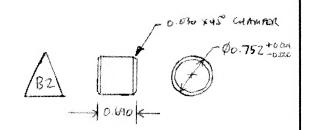
NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:												
Work Orde	•					DISPOSITION Rework		Skid-tube Crosstube			EPARTMENT/PROCESS Water Jet Engineering		
Part I	•					Scrap Use-as-is Work Order Update	Ţ	Machining Small Fab Thermoforming Finishing Large Fab Composite			Rec/Store/Packaging Other		
Root					Descri	ption of work order update	Init	ial	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
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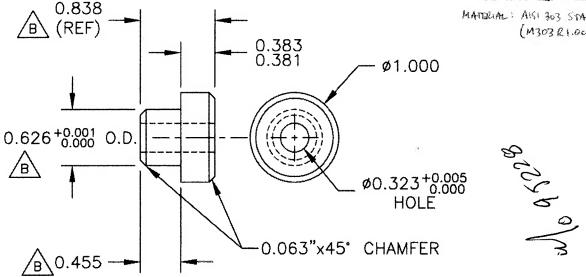


-	DESIGN (DRAWN BY		OSPACE LTD , ONTARIO, CANADA
1	CHECKED	APPROVED N	DRAWING NO.	REV. B
	#	#	D3177	SHEET 3 OF 3
	DATE	<u> </u>	TITLE	SCALE
	03.01.07		BRACKET	1:1



D3177-7 PUG

MATORIAL: AISI 303 STAINLESS STEEL (M303 R1.000)



D3177-5

1) MATERIAL: 6061-T6 ALUMINUM BAR Ø1.000

(QQ-A-200/8 OR QQ-A-225/8)

(REF DART SPEC. M6061T6R1.000)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



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DQA:	Date:		

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCN.	es / NO				WORK ORDER NOW				QA Closed:	Date	2:	
Work Orde	r:				DISPOSITION				EPARTMENT/PROCESS			
Part N	0				Rework Scrap Use-as-is	-J E	Skid-tube Crosstube Water Jet Engineeri Machining Small Fab Prod. Eng. Coor. Qual					
NCR N	o				Work Order Update		Thermoforming Finishing Rec/Store/Packaging Supplier				Other	
Root				Descri	ption of work order update	Initial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector	
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						AULT CATE	GORY					
Landin	ig Gear				General	<u> </u>		1	1	г		
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ļ	Centre Not Concentric to O/S			o/s	BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure	
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	Crushed/Crimped_				Burrs		tions Incomplete/l	Unclear			Wrong Stock Pulled	
Ļ	Cuffs .				Contamination	\vdash	enance	_	Part Moved			
	Heat Treat				Countersink	Mislabe		<u> </u>	Positioned V			
	Inspectio		Tube	<u> </u>	Cut Too Short	Misrea	b		Power Loss/	'Surge	Other	
L	Ripples in				Drill Holes	Offset						
Ĺ	—	Vaves in I		n	Drawing		Calibration					
	Turning S	Sequence			Finish	Out of	Sequence					
	Wave/Tv	vist in Tul	oe oc		Folio	Outside	e Dimensions					

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